

### **Amendments to the Specification**

At specification page 1 (i.e., the IPER-amended version of the specification), before the paragraph beginning with "[t]his is a nationalization of," insert the following heading:

CROSS-REFERENCE TO RELATED APPLICATION

At specification page 1 (i.e., the IPER-amended version of the specification), before the paragraph beginning with "[t]he invention relates to," insert the following headings:

BACKGROUND OF THE INVENTION

#### 1. Field of Invention

At specification page 1 (i.e., the IPER-amended version of the specification), replace the paragraph beginning with "[t]he invention relates to" with the following replacement paragraph:

The invention relates to a gusseted bag ~~according to the preamble of claim 1~~ produced and filled by a form-fill-seal (FFS) machine, a method for the production and filling of such a gusseted bag, and a corresponding form-fill-seal (FFS) machine.

At specification page 1 (i.e., the IPER-amended version of the specification), before the paragraph beginning with "[t]he generic filling of bags," insert the following heading:

#### 2. Description of the Prior Art

At specification page 2a (i.e., the IPER-amended version of the specification), before the paragraph beginning with "[i]t is therefore the object of the invention," insert the following heading:

#### SUMMARY OF THE INVENTION

At specification page 3, replace the paragraph beginning with "[o]wing to the inventive measure" with the following replacement paragraph:

Owing to the inventive measure, it is not possible for the fillers to trickle through the perforation cuts, which are arranged between the bag edge and the corner weld seal. The inventive measure is similarly suitable for ~~flat bags as specified in claim 1~~ flat bags as described herein.

At specification page 3, before the paragraph beginning with "[t]he individual figures illustrate," insert the following heading:

#### BRIEF DESCRIPTION OF THE DRAWINGS

At specification page 3, before the paragraph beginning "Figure 2 illustrates a gusseted bag 201," insert the following heading and paragraph:

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Further scope of applicability of the present invention will become apparent from the detailed description given hereinafter. However, it should be understood that the detailed description and specific examples, while indicating preferred embodiments of the invention, are given by way of illustration only, since various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description.

At specification page 4, replace the paragraph beginning with "[i]n contrast, figure 1" with the following replacement paragraph:

In contrast, figure 1 illustrates an already very advanced example of an inventive bag 200, which is provided with corner weld seals 206. Furthermore, it can be observed that the tear-off perforation breaks down into a tear-off perforation having longer perforation incisions 207 and a tear-off perforation having shorter perforation incisions 208. The longer perforation incisions 207 are located in the area between the edge of the bag 209 and the corner weld seal 206, while the shorter incisions 208 are located in the area between the centerline M of the bag 200 and the corner weld seal 206 of the corner, which is impinged with the tear-off perforation. It can be further observed that the bag 200 stands on its head as opposed to the bag 201. That is, the bottom end 210 of the bag ~~210~~ 200 is located in the upper area of figure 1, while the

top end 211 of the bag 200 is located in the lower area. The tear-off perforation incisions 207, 208 ~~is~~ are thus located in the area of the bottom end 210 of this bag 200, which proves to be advantageous in the filling process, which is still to be described.

At specification page 4, replace the paragraph beginning with "Figure 3 once again illustrates" with the following replacement paragraph:

Figure 3 once again illustrates the bottom ~~section~~ end 210 of the bag 200, which is already illustrated in figure 1 and whose characteristics are already described above.

At specification page 4, replace the paragraph beginning with "[p]assages (labyrinth ventilation) 229" with the following replacement paragraph:

Passages (labyrinth ventilation) 229 can be inserted in an inventive corner weld seal for better ventilation of the bag. It is expedient, if these passages 229 also do not let any filling material pass. The tear-off perforation of the bag 214 illustrated in figure 5 is designed differently. It is composed of a tear-off perforation ~~207~~ having long perforation incisions 207 and a perforation ~~208~~ having shorter perforation incisions 208, just as the tear-off perforation of the bag 200 does. However, this tear-off perforation is further provided with a perforation 215, which

permits a part of the ~~weld~~ bottom seam ~~208~~ 205 to be torn open, which seals bottom end 210 of the bag 214. This facilitates the process of tearing off this part.

At specification page 5, replace the paragraph beginning with "Figure 6 illustrates" with the following replacement paragraph:

Figure 6 illustrates a last embodiment of an inventive bag 217. Similar to the embodiment with the bag 200, a perforation having long perforation incisions 207 is present in the area between the edge 209 of the bag 217 and the corner weld seal 206. However, this applies to both the corners of the bottom ~~area~~ end 210 of the bag illustrated, said bottom ~~area~~ end 210 being illustrated in figure 6. Another perforation 216, which is formed by shorter perforation incisions is located between the two corner weld seals 206 of the bag 217.

At specification page 5, replace the paragraph beginning with "[c]omponents of an FFS machine" with the following replacement paragraph:

Components of an FFS machine are illustrated in figures 7 and 8. The position of these components can be seen *inter alia* in the figures of the German patent application 102 17 397.4, which is not yet published. The machine components illustrated are a web-cutting and welding station 230 and also a needling station 240.

However, the components normally provided for the needling and ventilation of the bag are used for perforation. The web-cutting and welding station 230 is usually located in an FFS machine in the front area of the processing cycle. The film tube 219 is usually unwound by an unwinder and is supplied using draw rollers 218 into the web-cutting and welding station 230. Figures 7 and 8 illustrate the web-cutting and welding station 230 starting with the pair of draw rollers, which is formed of the draw rollers 218. The film tube 219 runs through the roller clearance formed by these two draw rollers 218 and into the web-cutting~~[[,]]~~ and welding ~~and~~ ~~perforation~~ station 230. The perforation station 220 consists, in detail, of the holder of the knife support 221, to which the knife support 223, moveable in the x-direction, is linked. The knife support 223 supports the knife 228 and also the rubber squeeze 224. Should the knife support 223 move in the x-direction, the knife 228 travels through the scraper 226 or through a recess (not illustrated) of the scraper 226 and into the knife receiving channel 227, of the backing run 225 of the knife ~~225~~ 228. The backing run 225 of the knife ~~225~~ 228 is formed by a cross bar. In the transport direction z of the film tube, the ~~first~~ perforation station 220 is followed by the web-cutting and welding station 230, which in turn consists of the holder of the knife support 231, the knife support 233, the knife ~~226-[sic]~~ 238, the sealing jaw 234, the backing run 235, and the knife receiving channel 236 ~~and the knife-238~~. The incision movement of the knife 238 takes place

similarly to the incision movement in the ~~first~~ perforation station 220, which can also be seen on the basis of figure 8. Figure 8 illustrates the ~~first~~ perforation station 220, the web-cutting and welding station 230 and the ~~second possible~~ needling station 240 in the state in which they cut into the web of blown film and cut through or perforate the web of blown film. The ~~second~~ needling station 240 already mentioned above is designed similarly to the ~~first~~ perforation station 220. The functional elements 241-248 of the ~~second~~ needling station 240 are numbered similarly to the functional elements 221-228 of the ~~first~~ perforation station 220. Either of the two perforation stations, i.e., the perforation station 220 and the needling station 240, can be used for needling while the respective other station is used for perforation.

At specification page 6, replace the paragraph beginning with "Figure 9 illustrates" with the following replacement paragraph:

Figure 9 illustrates the section 250 of a film tube, into which the center cut 256 is inserted, thus dividing the film tube into two bags. It can be seen above the center cut 256 that the subsequently resulting bag is of the same type as the bag 200 illustrated in figures 1 and 3. The bottom end 210 of this bag can be seen above the center cut 256. The bag is provided above the bottom end with a cross-weld seam 258, which forms the bottom. Large perforation incisions 207 and shorter perforation incisions

208 are located in the area of one of the corners of the bag. In addition to the already illustrated features of the bag 200, figure 9 illustrates needlings 251, which specify, by way of example, that the bag can also be needled. Figure 9 also illustrates the inventive corner weld seals 206. However, it must be observed that the illustrated bag section need not be strictly present in this form during the production of the bag. Rather, it is possible, for example, that the corner weld seals 206 and the bottom seams 205 are added to the bag 200 even before its separation from the film tube 219. Therefore, the purpose of figure 9 in the first place is to illustrate the location of the various features of the bag 200.

At specification page 6, replace the paragraph beginning with "Figure 10 illustrates" with the following replacement paragraph:

Figure 10 illustrates a perforation tool 259, which consists of the perforation knives 253 and 252, which are attached to the knife support 254. These perforation knives cut into the film tube section 250. A four-layer film material 257 and a two-layer film material 260 are present in this ~~section of a~~ film tube section 250, said section also being illustrated in figure 9. The four-layer film material 257 is present in the area of the side-gussets while the two-layer film material 260 exists in the middle area of the bag. The arrows z and y in figures 9 and 10 illustrate the respective position of the bag components. Here, as in case of



the other figures, z corresponds to the transport direction of the film tube, while y runs in the direction of the width of the film tube and/or of the bags. The two figures 9 and 10 are aligned in the y direction wherein the right part of the film tube section 250 is not illustrated in figure 10. In addition, figure 10 illustrates that the knives 253 cut further into the film tube section 250 than the knives 252, thus bringing about the variable length of the perforation incisions 207 vis-à-vis the perforation incisions 208. The knives 253 and 252 are usually clamped on the knife support 254.

At specification page 7, after the last line, insert the following paragraph:

The invention being thus described, it will be apparent that the same may be varied in many ways. Such variations are not to be regarded as a departure from the spirit and scope of the invention, and all such modifications as would be recognized by one skilled in the art are intended to be included within the scope of the following claims.

At specification page 1/4 (i.e., the first claims page), replace the heading with the following replacement heading:

~~Claims~~ WHAT IS CLAIMED IS: